

Pipeweld 7016

Basic thin coated AC/DC electrode providing excellent mechanical properties. This electrode ensures fully penetrated root passes, even in adverse conditions. Low moisture content of the coating has a high resistance to moisture re-absorption.

Specifications

Classifications	SFA/AWS A5.1 : E7016-1 H4 R EN ISO 2560-A : E 42 5 B 1 2 H5
------------------------	--

Welding Current	AC, DC+(-)
Diffusible Hydrogen	< 4.0 ml/100 g
Alloy Type	Carbon manganese
Coating Type	Basic covering

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa	550 MPa	30 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-45 °C	150 J
As Welded	-50 °C	140 J

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.25	0.50

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Number of electrodes/kg weld metal	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
3.2 x 350.0 mm	80-140 A	22 V	61 %	52.0	53 sec	1.3 kg/h
4.0 x 350.0 mm	110-180 A	22 V	64 %	34.0	62 sec	1.7 kg/h